

Work Order ID 89836

Tuesday, September 11, 2012 10:28:17 AM

~~PRELIMINARY ISSUE~~ 89836*

Page 1

Item ID: D4713-1

Revision ID: PRELIM

Item Name: Spacer Half

Start Date: 9/11/2012 Start Qty: 4.00

Required Date: 9/14/2012 Req'd Qty: 4.00

Reference:

12-09-11

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4713	<i>PA/FA A</i>								
100	Hardinge CNC LATHE SMALL	0.00				<i>Y</i>	<i>Ø</i>		
100									
Doosan	Memo	0.00							
Doosan Lathe	TURN AS PER DWG FOLIO REV: <i>N/A</i> DWG REV: _____		<i>SA</i>	<i>12/9/13</i>					
	DEBURR								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				<i>Y</i>	<i>Ø</i>		
110									
QC	Memo	0.00							
Quality Control			<i>SA</i>	<i>12/9/13</i>					

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89836

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Tuesday, September 11, 2012 10:28:17 AM

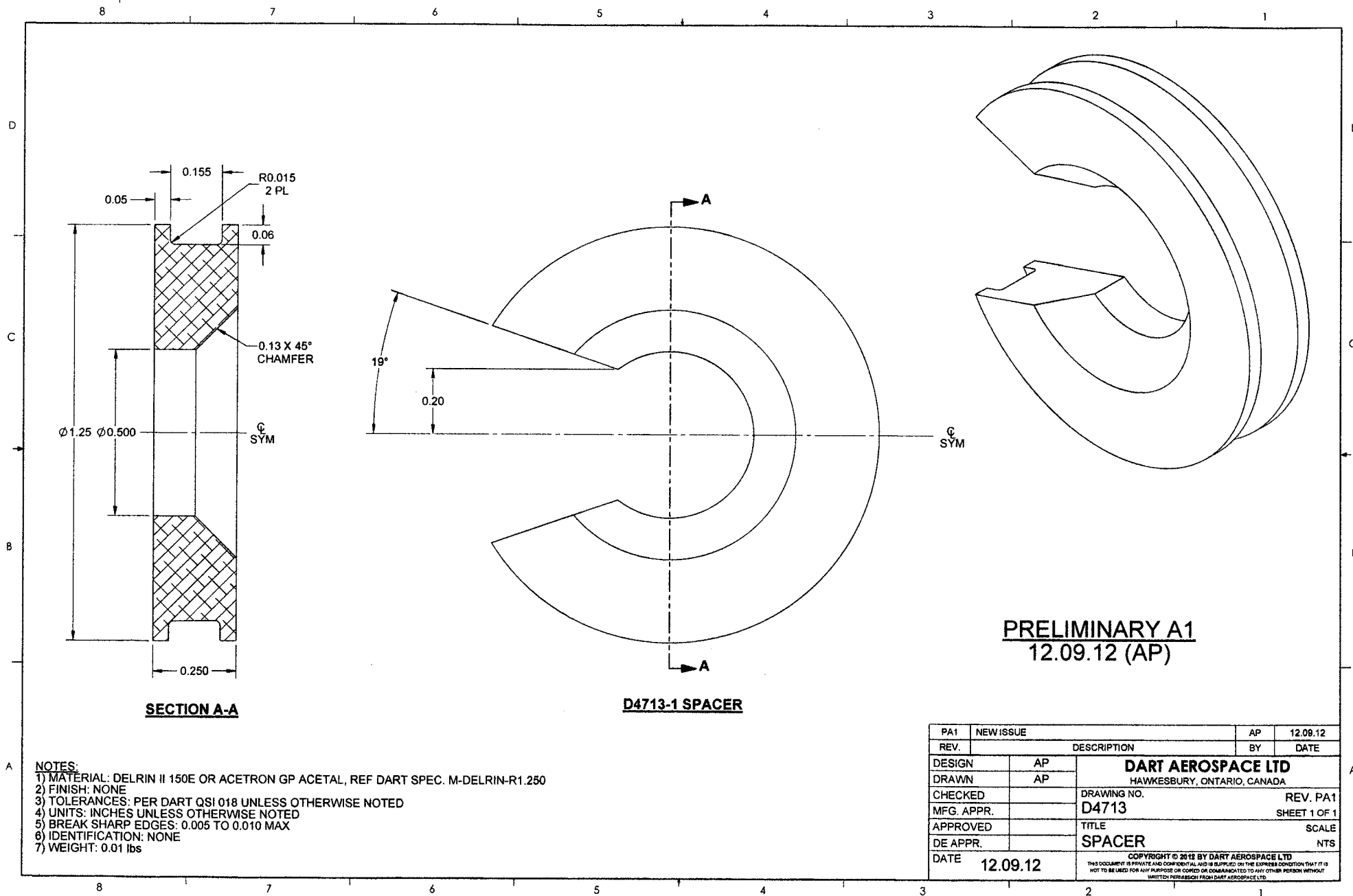
Item ID: D4713-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Spacer Half
 Start Date: 9/11/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 9/14/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

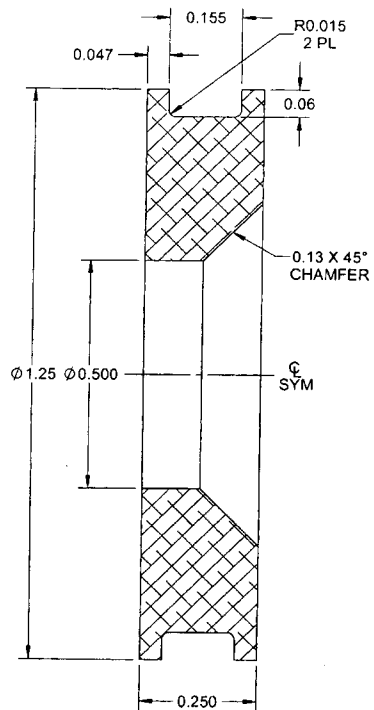
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>11p</u> Memo	0.00 0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

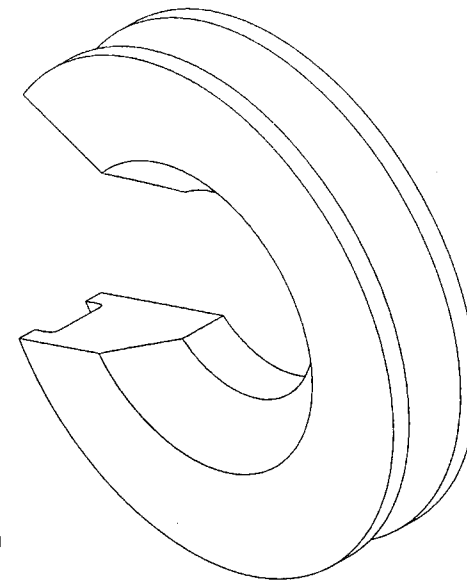
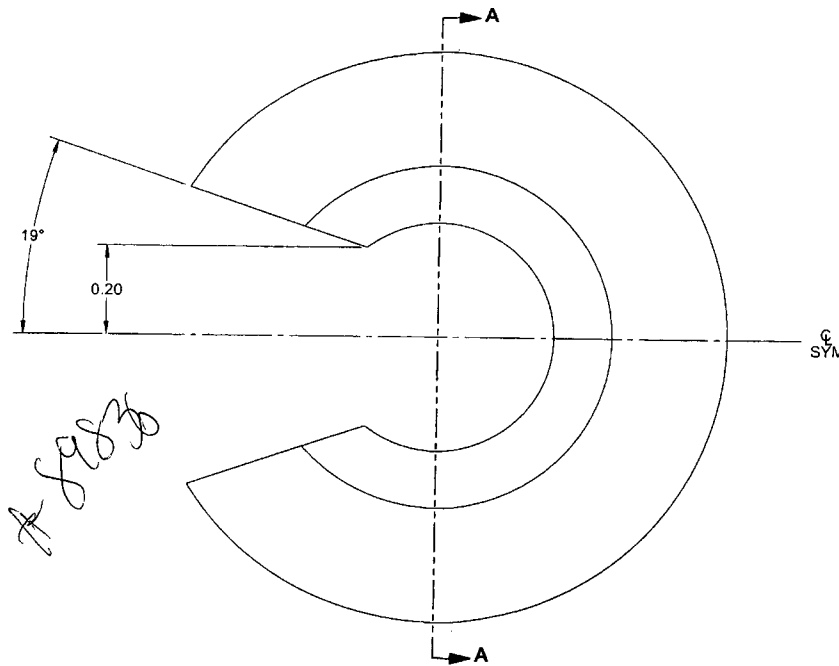
[Handwritten signature] 12-09-13 4 ϕ
 (42) 12/9/26 sl
 12/9/28 *[Handwritten signature]*

POSITIVE RECALL
 EFFECTIVE 12/9/11
 RELEASED 12/9/11
 DATE 12-09-24
 12 09-26
 60212647





SECTION A-A



RELEASED
2012-09-27

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, REF DART SPEC. M-DELRIN-R1.250
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

A	NEW ISSUE	AP	12.09.12
REV.	DESCRIPTION	BY	DATE
DESIGN	AP		
DRAWN	AP		
CHECKED	AP		
MFG. APPR.	AP		
APPROVED	AP		
DE APPR.	AP		
DATE	12.09.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4713** REV. A
SHEET 1 OF 1
TITLE **SPACER** SCALE NTS

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